

86886

July-09-12 9:15:59 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

6

6

Reference:

Run Start *NR1*

Stop *NR2*

Date:

**Insp.
Stamp**

Rev E

0.00

FLOW WATER JET

0.00

Memo

1-Cut as per Dwg D2175

Dwg Rev: F

Prog Rev:

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

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Work Order ID 86886

86886

Page 3

July-09-12 9:15:59 AM

Item ID: D2175-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle LH

Start Date: 7/09/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/27/12

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.00

Quality Control

DAS
16
2/6/25

(48)
1

8 7/12/12-7-24

8a

JP
12/07/12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 86886

86886

Page 4

July-09-12 9:15:59 AM

Item ID: D2175-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle LH

Start Date: 7/09/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location: *GF*

0.00

180

Packaging

Memo

0.00

Packaging

8x

12/07/06

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/17/30

MCS 12/07/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

July-09-12 9:15:59 AM

Work Order ID: 86886

Parent Item: D2175-1

Parent Item Name: Angle LH

Start Date: 7/09/12

Required Date: 7/27/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP E04.06.09ReformatKJ/RF
IPP Rev:F 06-04-28 Manufactured on Water Jet JLM
IPP Rev:G As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	239.8900	0.4722	2.9823156	41	12-7-24	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			(8)		
				MAT022		239.89							
				119916		67.35							
				121197		172.54							
										121197			

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DART AEROSPACE LTD		Work Order:	86886
Description: Angle		Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	2		T B01	
R0.35	+/-0.030	.35	2		R G,	
2.915	+/-0.010	2.916	2		V B02	
50°	+/-0.5°	50°	2			
0.300	+/-0.010	.302	2		V	
1.050 Pitch	+/-0.010	1.049	2		V	
10.500	+/-0.010	10.500	2		T	
11.550	+/-0.010	11.502	2		T	
0.550	+/-0.010	.547	2		V	
0.900	+/-0.010	.902	2		V	
0.063 thick	+/-0.010	.064	2		V	
Grain Direction	N/A		2			
Ø0.128	+0.005/-0.001	.129	2		V	
Ø0.172	+0.005/-0.001	.173	2		V	

Measured by: B	Audited by: SMB	Prototype Approval:	N/A
Date: 12-7-24	Date: 12-7-24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

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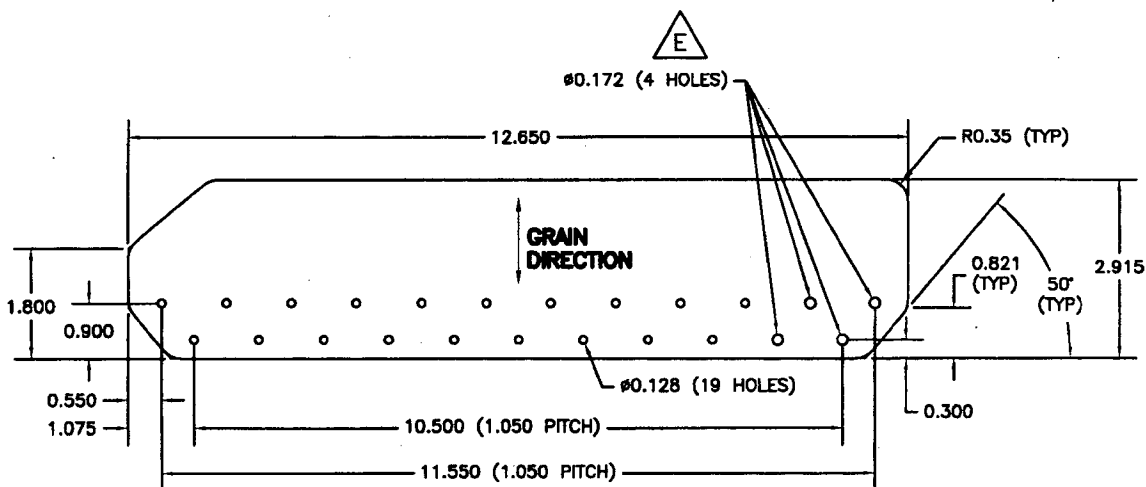
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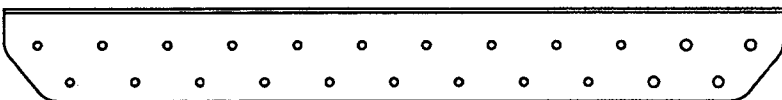
DART

RELEASED
06 10 13

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
RF		CE		REV. E	
CHECKED	APPROVED	DRAWING NO.		SHEET 1 OF 1	
PH	[Signature]	D2175		SCALE	
DATE		TITLE		SCALE	
06.09.25		ANGLE		1:3	
A	95.10.25	NEW ISSUE			
B	96.01.18	CHANGED DIMENSION			
C	00.09.11	UPDATE FINISH SPEC			
D	04.06.03	RE-DESIGN			
E	06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES			



D2175-1F FLAT PATTERN



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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